

Work Order ID 60705

Tuesday, July 20, 2010 8:08:48 AM



Page 1

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 7/20/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 7/26/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10/20/09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2572 | Rev E | | | | | | | | |

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

[Signature] 10/08/09

HAAS CNC vertical machine #1

Program Batch No. *[Signature]* 10/08/09

Double check by:

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

12 *[Signature]*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

[Signature] 10/08/09

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

12 *[Signature]*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 60705

Tuesday, July 20, 2010 8:08:48 AM



Page 2

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 7/20/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 7/26/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|----------|--------------|---------------|---------------|------------------|----------------|
| 120 QC Quality Control | QC2- Inspect parts off machine FAI/FAIB Memo | 0.00 0.00 | IST | 10/08/17 | | 12 | 0 | | |
| 130 QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | 28 | 10/08/18 | | 12 | 0 | | |
| 140 HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 12 | 08 | 18 | (12) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 60705

Tuesday, July 20, 2010 8:08:48 AM



Page 3

| | | | | | | |
|----------------|--------------------|------------|-------|---------------|-------|--|
| Item ID: | D2572 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Saddle, Fwd In 205 | | | | | |
| Start Date: | 7/20/2010 | Start Qty: | 12.00 | Cust Item ID: | | |
| Required Date: | 7/26/2010 | Req'd Qty: | 12.00 | Customer: | | |
| Reference: | | | | | | |

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|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|-----------|-----------------|--------------|-----------------|---------------|------------------|----------------|
| 150 Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 6:45 ^{pm} OVEN TEMPERATURE: 320° FINISH TIME: 7:15 ^{am} | 0.00 0.00 | | | | <u>ml</u> | <u>10</u> | <u>08</u> | <u>19</u> (12) |
| 160 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | <u>ml</u> | <u>10/08/19</u> | | <u>v10</u> | <u>0</u> | | |
| 170 Packaging Packaging | Identify as per dwg & Stock Location: <u>433</u> Memo | 0.00 0.00 | | | | <u>10/01/24</u> | <u>sf</u> | <u>132</u> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 60705

Tuesday, July 20, 2010 8:08:48 AM



Page 4

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 7/20/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 7/26/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/24

CL 10/8/24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 20, 2010 8:08:52 AM

Page 1

Work Order ID: 60705

Parent Item: D2572

Parent Item Name: Saddle, Fwd In 205




Start Date: 7/20/2010

Required Date: 7/26/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-005  Saddle Billet | | Manufactured | No | | | 100 | Each | 49.0000 | 1 | 12 | | | |

Location

Loc Qty

Loc Code

MAT46

49

46411

44

58676

5

12 ISS 10/08/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | |
|---|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 66705 |
| Description: Saddle, Fwd Inboard | Part Number: | D2572 |
| Inspection Dwg: D2572 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----------|--------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | | 0.440 | 0.441 | 0.441 | 0.441 | Vern | DJP-11 |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | " | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | " | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | " | |
| E | 7.990 | 8.010 | | 8.001 | 8.001 | 8.001 | 8.001 | " | |
| F | 0.490 | 0.510 | | 0.499 | 0.498 | 0.499 | 0.498 | " | |
| G | 0.257 | 0.262 | | 0.259 | 0.259 | 0.259 | 0.259 | " | |
| H | 0.375 | 0.380 | | 0.377 | 0.377 | 0.377 | 0.377 | " | |
| I | 0.490 | 0.510 | | 0.501 | 0.501 | 0.500 | 0.499 | " | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | " | |
| K | 0.558 | 0.578 | | 0.568 | 0.568 | 0.568 | 0.566 | " | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | " | |
| M | 1.490 | 1.500 | | 1.495 | 1.495 | 1.495 | 1.495 | " | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | " | |
| O | 3.869 | 3.879 | | 3.874 | 3.874 | 3.874 | 3.874 | " | |
| P | 0.115 | 0.135 | | 0.124 | 0.124 | 0.123 | 0.124 | mic | DJP-02 |
| Q | 0.115 | 0.135 | | 0.130 | 0.130 | 0.130 | 0.130 | Vern | DJP-11 |
| R | 0.240 | 0.260 | | 0.248 | 0.249 | 0.248 | 0.248 | mic | DJP-02 |
| S | 0.115 | 0.135 | | 0.132 | 0.130 | 0.132 | 0.131 | Vern | DJP-11 |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | Rad gage | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | 2.960 | 2.960 | Vern | DJP-11 |
| V | 0.230 | 0.250 | | 0.236 | 0.234 | 0.233 | 0.233 | " | |
| W | 0.115 | 0.135 | | 0.134 | 0.132 | 0.132 | 0.130 | deep mic | 118-Ro |
| X | 0.307 | 0.312 | | 0.311 | 0.311 | 0.311 | 0.311 | mic | DJP-02 |
| Y | 0.760 | 0.765 | | 0.762 | 0.762 | 0.762 | 0.762 | Vern | DJP-11 |
| Z | 0.352 | 0.372 | | 0.365 | 0.365 | 0.363 | 0.363 | " | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | Rad gage | |
| AB | 0.615 | 0.635 | | 0.615 | 0.618 | 0.618 | 0.619 | Vern | DJP-11 |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | Rad gage | |
| AD | 0.240 | 0.260 | | 0.247 | 0.246 | 0.246 | 0.245 | Vern | DJP-11 |
| AE | 1.375 | 1.395 | | 1.386 | 1.386 | 1.386 | 1.386 | Dial | |
| AF | 0.115 | 0.135 | | 0.130 | 0.130 | 0.130 | 0.130 | Vern | DJP-11 |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | Vern | DJP-11 |
| AH | 0.240 | 0.260 | | 0.246 | 0.246 | 0.244 | 0.244 | " | |
| AI | 2.000 | 2.020 | | 2.004 | 2.004 | 2.004 | 2.004 | Dial | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | Vern | DJP-11 |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|-----------------|
| Measured by: | DJA |
| Date: | 10/08/09 |

| | |
|-------------|-----------------|
| Audited by: | SR |
| Date: | 10/08/18 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| | | |
|---|--|---------------------------|
| DART AEROSPACE LTD | | Work Order: 66705 |
| Description: Saddle, Fwd Inboard | | Part Number: D2572 |
| Inspection Dwg: D2572 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|--------|----|------|
| | | | | 5 | 6 | 7 | 8 | | |
| A | 0.438 | 0.443 | | 0.441 | 0.441 | 0.441 | 0.441 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.001 | 8.001 | 8.001 | 8.001 | | |
| F | 0.490 | 0.510 | | 0.495 | 0.500 | 0.492 | 0.498 | | |
| G | 0.257 | 0.262 | | 0.259 | 0.259 | 0.259 | 0.259 | | |
| H | 0.375 | 0.380 | | 0.377 | 0.377 | 0.377 | 0.377 | | |
| I | 0.490 | 0.510 | | 0.500 | 0.500 | 0.5005 | 0.5005 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | 0.568 | 0.568 | 0.568 | 0.569 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| M | 1.490 | 1.500 | | 1.495 | 1.495 | 1.495 | 1.495 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 3.869 | 3.879 | | 3.874 | 3.874 | 3.874 | 3.874 | | |
| P | 0.115 | 0.135 | | 0.124 | 0.124 | 0.124 | 0.124 | | |
| Q | 0.115 | 0.135 | | 0.130 | 0.130 | 0.130 | 0.130 | | |
| R | 0.240 | 0.260 | | 0.248 | 0.248 | 0.248 | 0.248 | | |
| S | 0.115 | 0.135 | | 0.131 | 0.131 | 0.133 | 0.131 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | 2.960 | 0.188 | | |
| V | 0.230 | 0.250 | | 0.233 | 0.232 | 0.233 | 0.233 | | |
| W | 0.115 | 0.135 | | 0.131 | 0.130 | 0.130 | 0.130 | | |
| X | 0.307 | 0.312 | | 0.311 | 0.311 | 0.311 | 0.311 | | |
| Y | 0.760 | 0.765 | | 0.762 | 0.762 | 0.762 | 0.762 | | |
| Z | 0.352 | 0.372 | | 0.363 | 0.363 | 0.362 | 0.362 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.6185 | 0.618 | 0.618 | 0.619 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.500 | | |
| AD | 0.240 | 0.260 | | 0.247 | 0.246 | 0.244 | 0.246 | | |
| AE | 1.375 | 1.395 | | 1.385 | 1.3865 | 1.385 | 1.3855 | | |
| AF | 0.115 | 0.135 | | 0.130 | 0.130 | 0.130 | 0.130 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.244 | 0.244 | 0.246 | 0.244 | | |
| AI | 2.000 | 2.020 | | 2.003 | 2.0045 | 2.003 | 2.0035 | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | | |
| Accept/Reject | | | | | | | | | |

| |
|------------------------|
| Measured by: <i>DT</i> |
| Date: 10/08/12 |

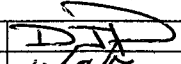
| |
|-----------------------|
| Audited by: <i>BP</i> |
| Date: 10/08/18 |

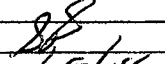
| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

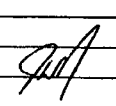
| | | | |
|---|--|---------------------------|--|
| DART AEROSPACE LTD | | Work Order: 60705 | |
| Description: Saddle, Fwd Inboard | | Part Number: D2572 | |
| Inspection Dwg: D2572 Rev. E | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|-------|----|------|
| | | | | 9 | 10 | 11 | 12 | | |
| A | 0.438 | 0.443 | | 0.441 | 0.441 | 0.441 | 0.441 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.001 | 8.001 | 8.001 | 8.001 | | |
| F | 0.490 | 0.510 | | 0.496 | 0.496 | 0.494 | 0.494 | | |
| G | 0.257 | 0.262 | | 0.259 | 0.259 | 0.259 | 0.259 | | |
| H | 0.375 | 0.380 | | 0.377 | 0.377 | 0.377 | 0.377 | | |
| I | 0.490 | 0.510 | | 0.501 | 0.500 | 0.501 | 0.500 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | 0.570 | 0.568 | 0.569 | 0.568 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| M | 1.490 | 1.500 | | 1.500 | 1.495 | 1.495 | 1.495 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 3.869 | 3.879 | | 3.874 | 3.874 | 3.874 | 3.874 | | |
| P | 0.115 | 0.135 | | 0.126 | 0.124 | 0.124 | 0.123 | | |
| Q | 0.115 | 0.135 | | 0.130 | 0.130 | 0.130 | 0.130 | | |
| R | 0.240 | 0.260 | | 0.249 | 0.248 | 0.248 | 0.247 | | |
| S | 0.115 | 0.135 | | 0.130 | 0.130 | 0.131 | 0.133 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | 2.960 | 2.960 | | |
| V | 0.230 | 0.250 | | 0.232 | 0.233 | 0.233 | 0.233 | | |
| W | 0.115 | 0.135 | | 0.129 | 0.131 | 0.131 | 0.131 | | |
| X | 0.307 | 0.312 | | 0.311 | 0.311 | 0.311 | 0.311 | | |
| Y | 0.760 | 0.765 | | 0.762 | 0.762 | 0.762 | 0.762 | | |
| Z | 0.352 | 0.372 | | 0.362 | 0.363 | 0.362 | 0.363 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.619 | 0.620 | 0.619 | 0.619 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.245 | 0.247 | 0.247 | 0.249 | | |
| AE | 1.375 | 1.395 | | 1.3875 | 1.3865 | 1.3855 | 1.385 | | |
| AF | 0.115 | 0.135 | | 0.130 | 0.130 | 0.130 | 0.130 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.244 | 0.245 | 0.245 | 0.244 | | |
| AI | 2.000 | 2.020 | | 2.005 | 2.004 | 2.004 | 2.003 | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | | |
| Accept/Reject | | | | | | | | | |

| |
|--|
| Measured by:  |
| Date: 10/08/17 |

| |
|---|
| Audited by:  |
| Date: 10/08/18 |

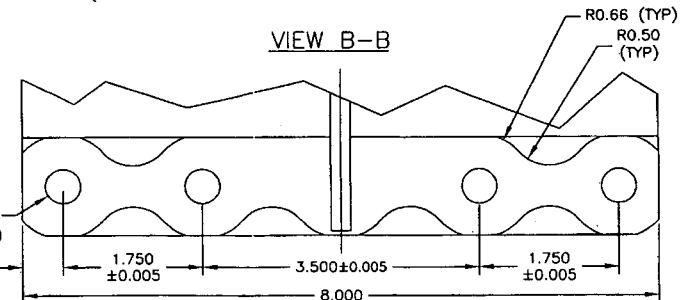
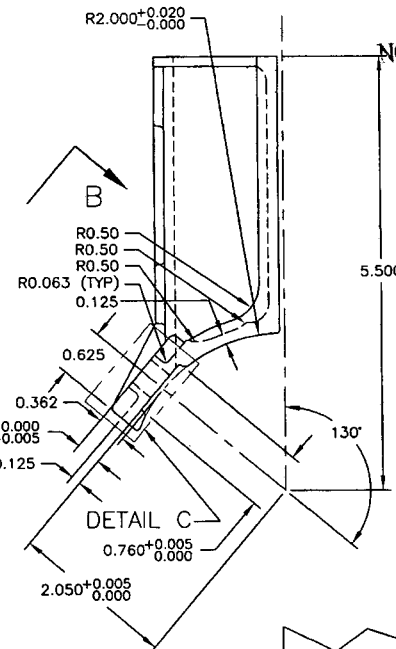
| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|---|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM |  |

NO. 60703
BSC-7-26

05.12.06 ~~th~~

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED




- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



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DETAIL C
SCALE 2:1

| | | | |
|--|---|--|---|
| E | 05.07.13 | ADD CHAMFER ON RIDGE NOTE 4 | |
| D | 02.09.06 | ADD RIDGES; TIGHTEN TOLERANCES | |
| C | 99.10.22 | INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177 | |
| B | 96.12.02 | ADD GRAIN DIR., 0.438 WAS 0.425 | |
| A | 96.09.16 | NEW ISSUE | |
| DESIGN DS | | DRAWN BY PH |  DART AEROSPACE LTD. HANDESBURY, ONTARIO, CANADA |
| CHECKED  | APPROVED  | DRAWING NO. D2572 | REV. SHEET 1 OF 1 |
| DATE 05.07.13 | | TITLE INNER FWD SADDLE | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries